

Work Order ID 83461

April-18-12 11:33:26 AM

Ship Today

83461

Page 1

Item ID: E4631-1

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Instrument Panel

Start Date: 18/04/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 25/04/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: MJS

Date: 12/04/18

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

E4631

A

100

0.00

100

FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg

Dwg Rev: A

Prog Rev: 1

6061-128

2- Deburr if necessary

110

0.00

110

QC

QC2- Inspect parts off machine FAI/FAIB

Memo

0.00

Quality Control

①

②

Jm
12-4-24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC8-Inspect parts - second check

0.00

120

QC

Memo

0.00

Quality Control

130

Chemical Conversion Coat per QSI005 4.1

0.00

130

HandFinish

Memo

0.00

Hand Finishing

2/6 12-4-23

140

QC7-Inspect Chemical Conversion Coat

0.00

140

QC

Memo

0.00

Quality Control

IX 12/04/23

Dart Aerospace Ltd

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1

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150

Identify as per dwg & Stock Location: *Eagle*

0.00

150

Packaging

Memo

0.00

Packaging

160

QC21- Final Inspection - Work Order Release

0.00

160

QC

Memo

0.00

Quality Control

*MLJ 12/04/23**062 04-23*

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Picklist Print

April-18-12 11:33:30 AM

Page 1

Work Order ID: 83461

83461

Parent Item: E4631-1

F4631-1

Parent Item Name: Instrument Panel

Start Date: 18/04/2012

Required Date: 25/04/2012

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP REV:A 12.04.11 NEW ISSUE DD VERF:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.125		Purchased	No			100	sf	60.7000	1.855	1.952632			

M6061T6S 125

**

6061-T6 .125 Sheet

Location	Loc Qty	Loc Code
MAT021	60.7	
113608	46.69	
119513	10.8	
120218	3.21	

121473

W for Jesse

12-04-23

JM
12-4-24

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NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 83461
Description: INSTRUMENT PANEL		Part Number: D4631-1
Inspection Dwg:	Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☒ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø 1.20	+ .004 - .001					
Ø 1.44	+ .005 - .001	1.50	2		X	13.52
Ø 1.50	+ .006 - .001	1.504	2		X	
Ø 1.630	+ .008 - .001	1.630	2		✓	
Ø 2.300	+ .012 - .001	2.300	2		✓	
Ø 3.170	+ .012 - .001	3.169	2		✓	
3.37	± .030	3.368	2		✓	
1.00	± .030	1.999	2		✓	
6.25	± .030	6.244	2		✓	
9.00	± .030	8.998	2		✓	13.507
.70	± .030	1.703	2			
.90	± .030					
1.78	± .030					
1.98	± .030	1.973	2		✓	
3.78	± .030					
10.93	± .030	10.905	2		P	
11.74	± .030	11.728	✓		P	
13.03	± .030	13.03	2		T	
1.20	± .030	1.197	2		V	
1.75	± .030	1.747	2		V	
2.25	± .030	2.244	2		V	
4.31	± .030	4.310	2		V	
5.75	± .030	5.75	2		V	

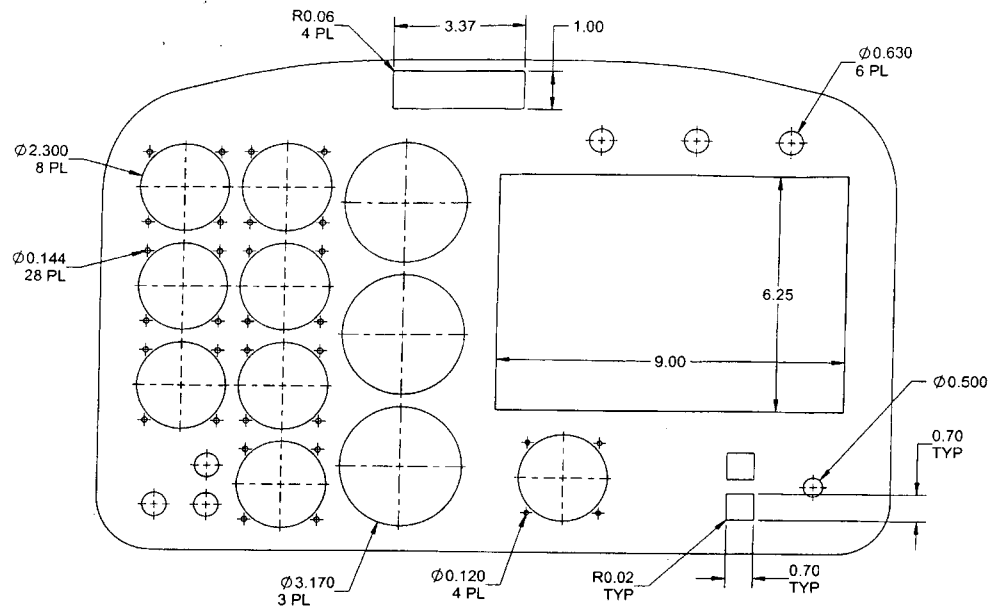
Measured by: RB	Audited by:	Prototype Approval:
Date: 12-4-23	Date:	Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

SHOP COPY
RETURN 1
ENGINE KING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

NO 83401 MCV
12/04/18

0.125
REF



E4631-1 INSTRUMENT PANEL

NOTES:

- 1) MATERIAL: 2024-T3 ALUMINUM SHEET, 0.125 THICK
PER QQ-A-250/4 OR AMS-QQ-A-250/4
OR AMS 4037 OR ASTM B209
REF DART SPEC M2024T3S.125
OR
6061-T6/T62 ALUMINUM SHEET, 0.125 THICK
PER QQ-A-250/11 OR AMS-QQ-A-250/11
OR AMS 4025 OR AMS 4027 OR ASTM B209
REF DART SPEC M6061T6S.125
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER DART QSI 044 6.1
- 7) WEIGHT: 0.62 lbs

RELEASED
2012-04-05

A NEW ISSUE		DESCRIPTION		BY	DATE
REV.					
DESIGN		EAGLE COPTERS LTD CALGARY, ALBERTA, CANADA			
DRAWN					
CHECKED		DRAWING NO.		REV. A	
MFG. APPR.		E4631		SHEET 1 OF 2	
APPROVED	N/A	TITLE		SCALE	
DE APPR.	N/A	INSTRUMENT PANEL		NTS	
DATE	12.04.04	COPYRIGHT © 2012 BY EAGLE COPTERS LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM EAGLE COPTERS LTD.			

W/O:		WORK ORDER CHANGES					
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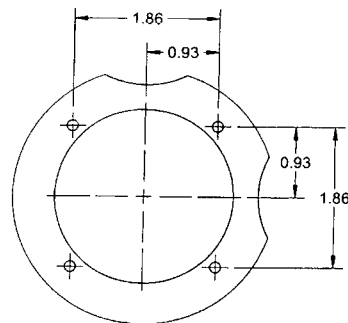
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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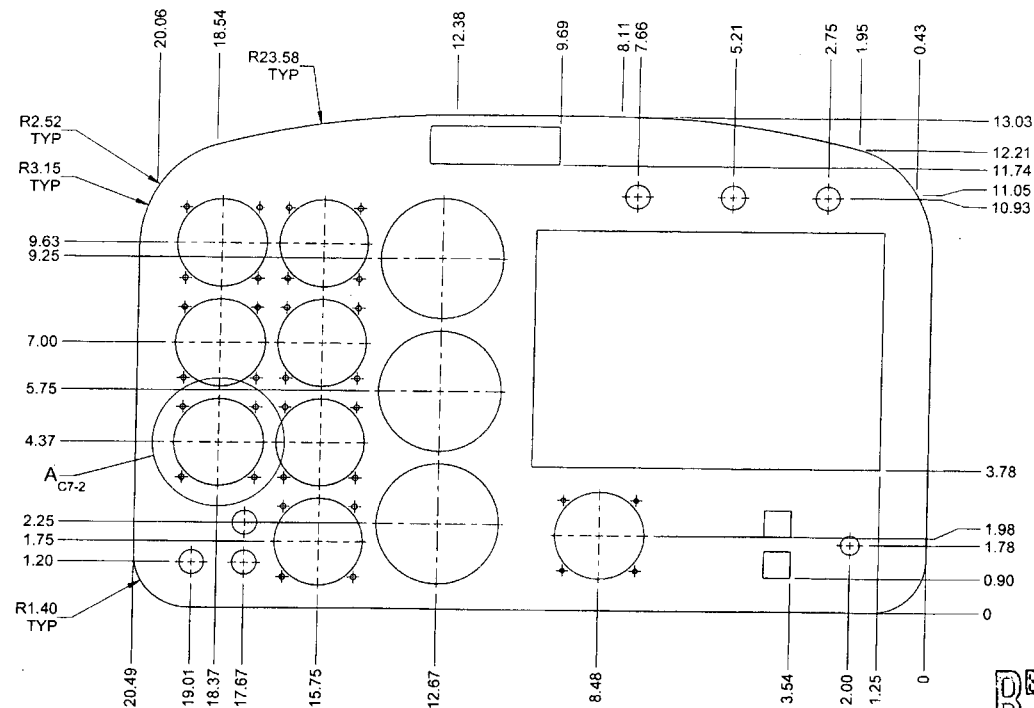
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83461



DETAIL A
8 PL 85-2



E4631-1 INSTRUMENT PANEL
AUXILIARY VIEW

RELEASED
R 2012-04-05

DESIGN		EAGLE COPTERS LTD	
DRAWN		CALGARY, ALBERTA, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		E4631	SHEET 2 OF 2
APPROVED	N/A	TITLE	SCALE
DE APPR.	N/A	INSTRUMENT PANEL	NTS
DATE	12.04.04	<small>COPYRIGHT © 2012 BY EAGLE COPTERS LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM EAGLE COPTERS LTD</small>	

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[8:46:20 AM] Linda Lacelle: Harvey?
[8:46:36 AM] Harvey Siemens: GML
[8:46:46 AM] Linda Lacelle: D4631 panel...just did the FAI and the measurments are no good...
[8:46:57 AM] Linda Lacelle: can you check the dcf pls
[8:47:00 AM] Linda Lacelle: dxf
[8:47:35 AM] Harvey Siemens: Which project is that for?
[8:48:11 AM] Linda Lacelle: it was for a PO sent in on Thursday from Eagle...PO 12-001737
[8:48:19 AM] Harvey Siemens: Ok, got it
[8:48:28 AM] Linda Lacelle: might as well check the D4629-1 also..PO 12-001735
[8:48:58 AM] Harvey Siemens: ok will do
[8:49:05 AM] Linda Lacelle: thx
[8:52:23 AM] Harvey Siemens: Is there a particular dim thats out?
[8:52:36 AM] Harvey Siemens: Nothing has changed as far as i can tell here.
[8:53:28 AM] Linda Lacelle: measuring from the side where the square side is, it's all off..
[8:54:45 AM] Linda Lacelle: like 1/4"
[8:55:54 AM] Harvey Siemens: Let me check
[9:29:17 AM] Harvey Siemens: Dont know what to say Linda, DXF matches the part at my end.
[9:29:29 AM] Harvey Siemens: Shall i remake the DXF and send it to you?
[9:29:56 AM] Harvey Siemens: E4629 looks good too ... at my end
[9:43:20 AM] Linda Lacelle: maybe we should just send the parts?
[10:21:23 AM] Linda Lacelle: so?
[11:34:55 AM] Harvey Siemens: Send me the parts and i'll see if they will work
[11:37:00 AM] Linda Lacelle: ok, thx